	er ID 117162 9, 2014 11:35:50 AM	D3561-1 B117162	*117	162*				Page 1
Revision ID:	D3561-1 Seal Insert Tool		Accept	*N900040	ງ 100)* s	Setup Star Stop	14.2.1
Start Date: Required Date: Reference:	4/23/14 Start Qty: 20 4/23/14 Req'd Qty: 20	/ \ 1		Cust Item ID: Customer:				
Approvals:	Process Plan:QC:	Date: 14-6-9	Tooling: SPC (Y/N):	Date:Date:		R	Run Star Stop	"IVH I"
Sequence ID/ Work Center II	Operation Description		Set Up/ Run Hours	Tool ID Tool #	# Plan Code	Accept Qty	Reject Qty	Reject Insp. Number Stamp
Draw Nbr	Revision Nbr Rev A					4 -3	2.5	Namber Stamp
*105 *105* Purchasing Purchasing	Memo ISSUE CUT A	~ \ \ \ \ \ - \ \ \ \ \ \ \ \ \ \ \ \ \	0.00			CX	1 14/10	06/12 20
*115 *1 1 5* Packaging Packaging	Receive & Inspect f	for Damage & Mat'l Certs	0.00] 17/1/	15 (20)
125 *195* QC Quality Control	QC6- Inspect dimer	nsions to drawing	0.00 DAS 27, 9-89 0.00))		∞		

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QA Closed:			Date:			WORK ORDER NON	-C(ONFO	RMANCE / UF		Vork Order uj	odate only	AEROSPACE
						DISPOSITION					•	······································	
Work Orde	er:					DISPOSITION				AGAINSI L	PEPARTMENT	PROCESS	
	•					Rework			Skid-tube	Crosstube		Water Jet	Engineering
Part N	lo.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
						Use-as-is		Therr	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR N	١٥٠ ـ					Suspected Unapproved			Large Fab	Composite		Supplier	
Doot	-		1 1		Doss	rintion of work order undete	Т	Initial	Acti		Cian 9		1
Root Cause		Date	Step	Qty	Desc	ription of work order update or non-conformance	1	iiiiliai iief Eng	Descri		Sign & Date	Verification	QC Inspector
Design		Date	Step	Qty		or non-comormance	-	ilei Liig	Descri	ption	Date	Verification	QC IIISPECTOI
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i	$\boldsymbol{\vdash}$	Cracks				Broken/Damage/Defect	_	Hardwa		<u> </u>	Part Incorre	H-	Temperature/Cure
	-	Crimp/Kii	nk/Ripple,	/Wave	-	Burrs	\vdash	4 '	ion Incomplete/Un		Part Lost/M	issing	Weld
	-	Cuffs			-	Contamination	_	4	tions Incomplete/U	nclear	Part Moved	L.	Wrong Stock Pulled
	-	Crushing			\vdash	Countersink	\vdash	4	gned/off center	-	Positioned V Power Loss/		Other
	\vdash	Heat Trea		T., b. a	-	Cut Too Short	\vdash	Mislabe		L		Surge [Other
	-	Inspectio	-	iupe	-	Drawing Drill Holos		Misrea Off-set				<u> </u>	
	-	Marks/Ch Turning S			-	Drill Holes Finish	-	4	Calibration				
!	H	Wave/Tw	•		-	Fit/Function	\vdash	4	Sequence			· · · · · · · · · · · · · · · · · · ·	
		wave/IW	, 13 C 111 T U U	<i>,</i>		prigramenon		Tour of	Jequence				

117162

Page 2

Monday, June (9, 2014 11:3	5:50 AM			1 agc 2	_							
Item ID: Revision ID: Item Name:	D3561-1 Seal Insert To	nol		Accept	ი4ი	100)*	_	tart top		S1* S2*		
Start Date: Required Date Reference:	4/23/14	Start Qty: 20.00 Req'd Qty: 20.00	*20* *20*		Cust Item I Customer:	D:					"IV.		
Approvals:	Process Pla	an:	Date:	Tooling: SPC (Y/N):		ate:				tart top		R1* R <i>2</i> *	
Sequence ID/ Work Center I 130 *120* Small Fab Small Fab	D	Operation Description Small Fab Memo Deburr if near	cessary.	Set Up/ Run Hours 0.00	Tool ID	Tool # DA 30 9-8	ο γ	Accept Qty	Reject Qty		Reject Number	Insp. Stamp	
140 *1 A N* Brake NC Brake NC	,	NC BRAKE Memo Form as per	Dwg D3561	0.00		D/ 3 9-	0	20		 -		(4/07)	/ Z
150 *150* QC Quality Control		QC5- Inspect part compl Memo	eteness to step on W/O	0.00 BB 14/67/2 0.00	DAS 27 9-8:			(20))				

DQA:		- 	Date:										
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Part N	ο.					Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
						Use-as-is	1		noforming	Finishing	⊣	re/Packaging	
NCR N	o. <u>.</u>					Suspected Unapproved]		Large Fab	Composite]	Supplier	
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Work	Order ID	117162
.1		

117162

Page 3

Monday, June 09, 2014 11:35:50 AM Item ID: D3561-1 Accept *N900040100* Setup Start **Revision ID:** Stop **Item Name:** Seal Insert Tool **Start Date: Start Qty: 20.00** 4/23/14 *20* **Cust Item ID:** Required Date: 4/23/14 Req'd Qty: 20.00 *20* **Customer:** Reference: Run Start **Approvals: Process Plan:** Date: **Tooling:** Date: Stop QC: Date: SPC (Y/N): Date: *NR2* Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. **Work Center ID Description Run Hours** Qty Code Qty Number Stamp 160 Identify as per dwg & Stock Location: \$\forall TO49 0.00 DAS *160* 20 Packaging 0.00 Memo Packaging 170 QC21- Final Inspection - Work Order Release *170* -MF QC 0.00 Memo Quality Control

DQA:		Date:			···································							
QA Closed:		Date:			WORK ORDER NON-	-C(ONFO	RMANCE / UPDATE	w	ork Order up	odate only	AEROSPACE
Work Orde	·r·				DISPOSITION			AGAIN	NST DE	PARTMENT	/PROCESS	
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Part No.				Scrap			Machining Small I		Pro	d. Eng. Coor.	Quality	
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ļ	Centre No	ot Conce	ntric		BOM/Route		Grain		<u> </u>	Over/Under	<u> </u>	Set-up
}	Cracks				Broken/Damage/Defect		Hardwa		\vdash	Part Incorre	├	Temperature/Cure
1	Crimp/Kir	ık/Ripple	e/Wave		Burrs		4	ion Incomplete/Unqualified	<u> </u>	Part Lost/Mi	ssing	Weld
ļ	Cuffs				Contamination	<u> </u>	4	ions Incomplete/Unclear	<u> </u>	Part Moved	L	Wrong Stock Pulled
ļ	Crushing			<u> </u>	Countersink	<u> </u>	1	ned/off center		Positioned V	_	_
1	Heat Trea				Cut Too Short	_	Mislabe		L.	Power Loss/	Surge	Other
]	Inspection	-	Tube	<u> </u>	Drawing	<u></u>	Misread			-		
ļ	Marks/Ch				Drill Holes	$oxed{oxed}$	Off-set					
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Wave/Twist in Tube				Fit/Function		Out of	Sequence					

Picklist Print

Monday, June 09, 2014 11:36:59 AM

Work Order ID: 117162

117162

Parent Item:

D3561-1

D3561-1

Parent Item Name: Seal Insert Tool

Start Date: 4/23/14

Required Date: 4/23/14

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP: A06.10.19New issueEC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Primary Item Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA		Purchased	No		100	sf	_138.3000	0.0473	1			
M304S11	GA					•		**	02	1 14/06/1	19	

304/316 0.125 Sheet

Location	Loc Qty	Loc Code	
MAT020	138.3		
122521	30		
M128254	108.3		

m129545

DQA:		_ Date:			TOAPT							
QA Closed:		Date:			WORK ORDER NON-	-C(ONFO	RMANCE / UPDATE	\٨/	ork Order u	odate only	AEROSPÀCE
Q. 1 0.030 Q.		- Dute.					<u> </u>			PARTMENT		
Work Orde	r:				DISPOSITION							
					Rework		Skid-tube Crosstub			1	Water Jet	Engineering
Part No.					Scrap		Machining Small Fa			Pro	d. Eng. Coor.	Quality
					Use-as-is		Thern	noforming Finishing		Rec/Sto	re/Packaging	Other
NCR N	o				Suspected Unapproved			Large Fab Composite	Ŀ	j	Supplier]
Root		I		Desci	ription of work order update		Initial	Action		Sign &		
Cause	Date	Step	Qty	Desci	or non-conformance		nief Eng			Date	Verification	QC Inspector
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_	Centre N	ot Conce	ntric	_	BOM/Route		Grain		┕	Over/Under		Set-up
	Cracks				Broken/Damage/Defect		Hardwa		ļ	Part Incorre		Temperature/Cure
Ļ	Crimp/Ki	nk/Ripple	e/Wave		Burrs	_	1	ion Incomplete/Unqualified	<u>_</u>	Part Lost/Mi	ssing	Weld
	Cuffs				Contamination	-	4	ions Incomplete/Unclear	\vdash	Part Moved	<u>.</u>	Wrong Stock Pulled
-	Crushing			_	Countersink	-	1 7	ned/off center	_	Positioned V		ا
-	Heat Trea				Cut Too Short	<u> </u>	Mislabe			Power Loss/	Surge	Other
	Inspectio	-	Tube		Drawing		Misread	3				
-	Marks/Ch				Drill Holes	\vdash	Off-set					
			Finish		4	Calibration						
Wave/Twist in Tube				Fit/Function		Out of S	Sequence					

DART AEROSPACE LTD	Work Order:	117167
Description: Seal Insert Tool	Part Number:	D3561-1
Inspection Dwg: D3561 Rev: A		Page 1 of 1

,		X First Art	icle	Prote	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Co	mments
1.00	+/-0.030	1.01			QS1-07		
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0.57	+/-0.030	0.57/	<i></i>		, v		
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easured by:	27	Audited by:	27 19-8	/ ₉ / [Prototype Approv	/al:	N/A
Date:	1417/1	Date:	1 11 4	<i> </i>	Da	ite:	N/A

nev	Date	Change	Kevisea py	Approved
Α	07.05.10	New Issue	KJ/JLM	E

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T.P.I. INDUSTRIES INC 148 GOODFELLOW DELSON, QUÉBEC J5B 1V4 CANADA Tel: (450) 633-0484 Fax: (450) 633-0879

Tracking No.:

Packing Slip

Packing Slip No.:

6181

Date:

2014-07-07

Page:

Sold to:		Ship to:		20 - 12. 1 - 1
Dart Aerospace Michael Grégoire 1270 Aberdeen Hawkesbury, Ontario K6A 1K7 Canada		Dart Aerospace Michael Grégoire 1270 Aberdeen Hawkesbury, Ontario K6A 1K7 Canada		
, oanada		And a second sec		
Order No.: 24545		Sold By:	JONATHAN LESSARD	
Shipped By:	t to relate	Ship Date:	2014-07-07	

Terra Mar	almi		Desention	(คิทสากที่จุนัก)
d2232-3	Chaque	d2232-3 basket hinge		2
d2534	Chaque	d2534 lock plate	· · · · · · · · · · · · · · · · · · ·	4 2
d3198-1	Chaque `	d3198-1 fitting	 ≱	8
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13561-1	Chaque	d3912-5 eyebolt plate	, we	2
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				Ž
13953-19 13953-19	Chaque Chaque	d3953-19 gas spring bracket d3953-19 gas spring bracket		
13953-19	Chaque	d3953-21 gas spring bracket		5
13953-2 1 13955-7	Chaque	d3955-7 plate		
14021-1	Chaque	d4021-1 handle plate		
14021-1 14149-1	Chaque	d4149-1 crosstube lug plate aft		4
14149-1 14150-3	Chaque	d4150-3 arm plate	•	
d4148-1		d4148-1 crosstube lug plate fwd		4
	Chaque	d4151-1 lower hardpoint plate		3
d4151-1	Chaque	d4151-1 lower hardpoint plate		
d4151-3	Chaque	d4151-3 upper hardpoint plate		
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